

Work Order ID 53439

November 4, 2009 11:51:36 AM



Page 1

Item ID: D3957-3

Accept



Setup Start



Revision ID: A

Item Name: Hinge, Door LH Lower

Stop



Start Date: 11/04/09 Start Qty: 6.00



Cust Item ID:

Required Date: 11/10/09 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

W

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3957

A

100

0.00



Bandsaw

Memo

0.00

Jeaspa Bandsaw

cut blank to 3.200" long

DJP 09/11/10

6 0

110

0.00



HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine as per Folio FA839

FOLIO REV: *AA*

DWG REV: *AA*

DJP 09/11/11

6 0

2-FINISH TAPPING TO FULL DEPTH BY HAND AS PER DWG

3-DEBURR AS PER DWG

B.A 09/11/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53439

November 4, 2009 11:51:36 AM



Page 2

Item ID: D3957-3

Accept



Setup Start



Revision ID: A

Stop



Item Name: Hinge, Door LH Lower

Start Date: 11/04/09 Start Qty: 6.00



Cust Item ID:

Required Date: 11/10/09 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00	DIP 09/11/11			6	0		
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	MW- 09/11/12			6	0		
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00	=> M 09/11/12			(X6)	0		

Work Order ID 53439

November 4, 2009 11:51:37 AM



Page 3

Item ID: D3957-3

Accept



Setup Start



Revision ID: A

Item Name: Hinge, Door LH Lower

Stop



Start Date: 11/04/09 Start Qty: 6.00



Cust Item ID:

Required Date: 11/10/09 Req'd Qty: 6.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

START 10:00AM

0.00

Powder Coating

MASK THREADED HOLE

TEMP 320°F

FIN 10:30AM

→ H 09/11/12

(X6)

8

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

OK 09-11-12

(2)

170

Identify as per dwg & Stock Location: GL

0.00



Packaging

Memo

0.00

Packaging

SB 09/11/12

(6)

Work Order ID 53439

November 4, 2009 11:51:37 AM

Page 4

Item ID: D3957-3

Accept

Revision ID: A

Item Name: Hinge, Door LH Lower

Start Date: 11/04/09 Start Qty: 6.00

Required Date: 11/10/09 Req'd Qty: 6.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/13 *[Signature]**MF*
09-11-12

Picklist Print

November 4, 2009 11:51:35 AM

Page 1

Work Order ID: 53439

Parent Item: D3957-3A-PRELIM

Parent Item Name: Hinge, Door LH Lower

Start Date: 11/04/09

Required Date: 11/10/09

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B0.750X03.00 0		Purchased	No			100	f	61.8700	1.6838			



6061-T6 Bar .750 x 3.00

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	61.87	
104741	30.62	
14252	12	
15211	19.25	

1.6838 *ISJ 09/10*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 53439
Description: Hinge, Door LH Lower		Part Number: D3957-3
Inspection Dwg:	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

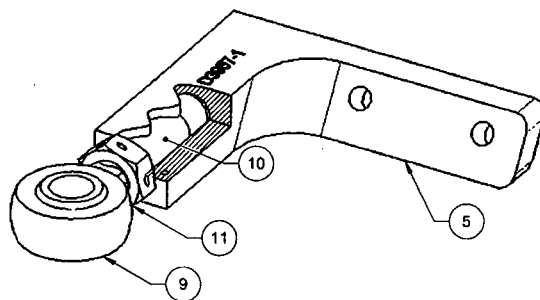
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.69	±0.030	0.690	✓			
0.281	±0.010	0.281	✓			
0.281	±0.010	0.281	✓			
3.00	±0.030	3.001	✓			
R0.13	±0.030	0.130	✓			2 PL
0.563	±0.010	0.564	✓			
1.25	±0.030	1.260	✓			REF
1.93	±0.030	1.935	✓			
107°	± 1/2°	107°	✓			
0.250	±0.010	0.250	✓			
Ø0.203	+0.005/-0.001	0.205	✓			2 PL
1.170	±0.010	1.170	✓			
0.39	±0.030	0.383	✓			
0.33	±0.030	0.319	✓			
Ø0.063	+0.004/-0.001	0.063	✓			
0.125	±0.010	0.123	✓			
0.094	±0.010	0.093	✓			
0.12	±0.030	0.140	✓			
R0.50	±0.030	0.500	✓			

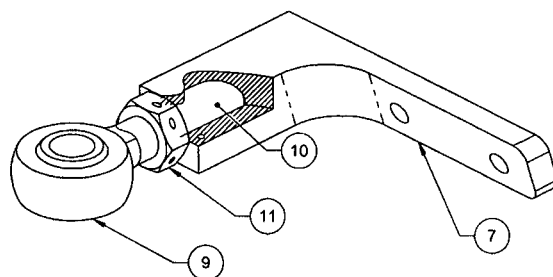
Measured by: DJP	Audited by: mme	Prototype Approval:	N/A
Date: 09/11/11	Date: 09/11/12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

ITEM	QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
1	X				D3957-041	HINGE ASSEMBLY, DOOR LH UPPER
2		X			D3957-042	HINGE ASSEMBLY, DOOR RH UPPER
3			X		D3957-043	HINGE ASSEMBLY, DOOR LH LOWER
4				X	D3957-044	HINGE ASSEMBLY, DOOR RH LOWER
5	1				D3957-1	HINGE, DOOR LH UPPER
6		1			D3957-2	HINGE, DOOR RH UPPER
7			1		D3957-3	HINGE, DOOR LH LOWER
8				1	D3957-4	HINGE, DOOR RH LOWER
9	1	1	1	1	D3518-3	ROD END
10	1	1	1	1	MS124818	HELICOIL, 3/8-24 UNF
11	1	1	1	1	NAS509-6	NUT

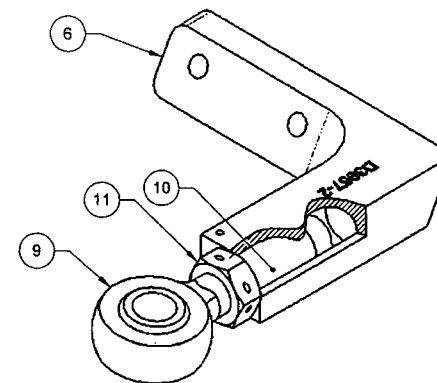


D3957-041 HINGE ASSY, DOOR LH UPPER

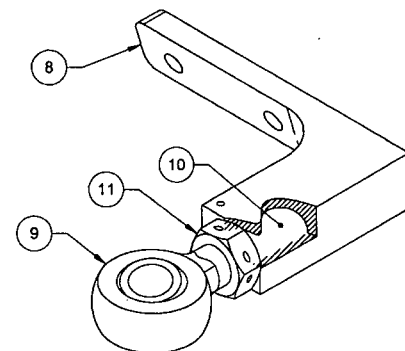


D3957-043 HINGE ASSY, DOOR LH LOWER

W/O 53439



D3957-042 HINGE ASSY, DOOR RH UPPER



D3957-044 HINGE ASSY, DOOR RH LOWER

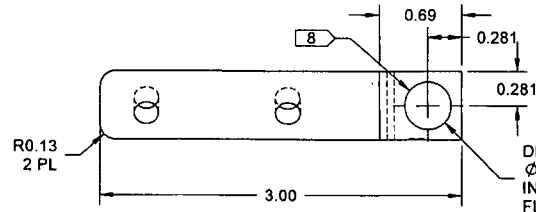
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2009-10-03
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REV.	DESCRIPTION	BY DATE
DESIGN		
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APPROVED		
DE APPR.		
DATE	09.09.03	

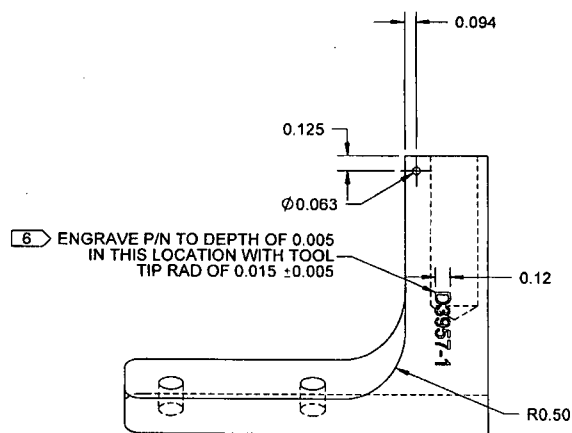
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3957	REV. A SHEET 1 OF 5
TITLE HINGE	SCALE NTS

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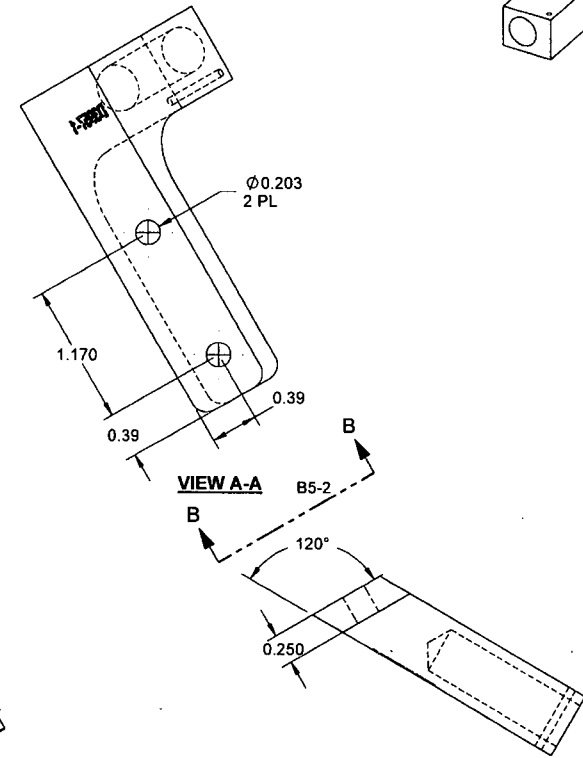
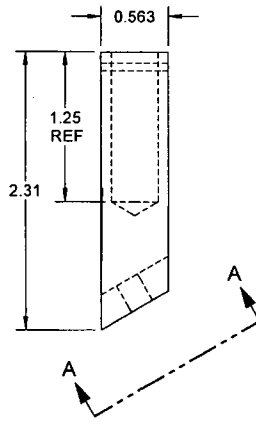
W/O 53439



DRILL AND TAP FOR 3/8-24 HELICAL INSERT
 $\phi 0.391$ X 1.25 DP
 INSTALL HELICOIL MS124818
 FLUSH WITH SURFACE

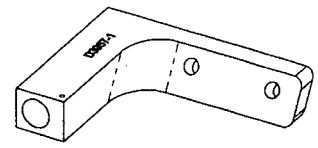


6 ENGRAVE P/N TO DEPTH OF 0.005
 IN THIS LOCATION WITH TOOL
 TIP RAD OF 0.015 ± 0.005



VIEW A-A

VIEW B-B



D3957-1 HINGE, DOOR LH UPPER

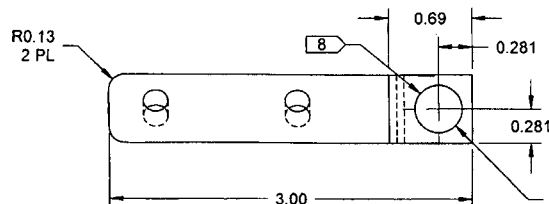
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 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
 PER AMS-QQ-A-200/8 (OR AMS 4160)
 REF DART SPEC M6061T6B
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
 - 7) WEIGHT: 0.10 lbs
 - 8) MASK HOLE PRIOR TO POWDER COAT

C3-2

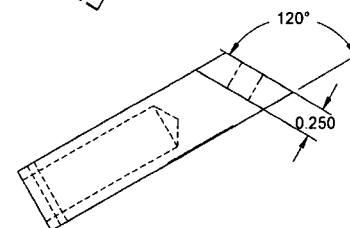
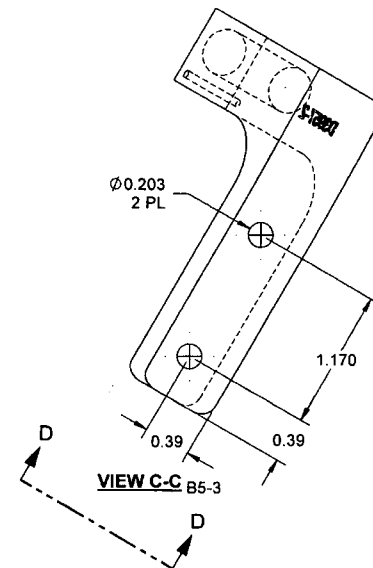
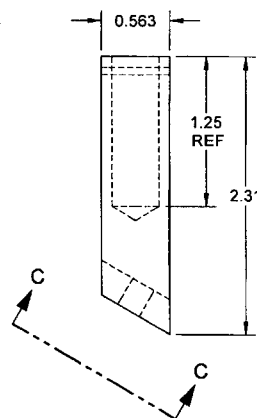
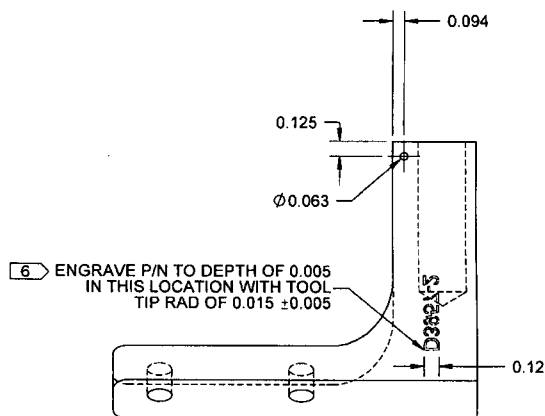
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 2009-10-08

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CHECKED	<i>PH</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>PH</i>	D3957	SHEET 2 OF 5
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W/D 53439



DRILL AND TAP FOR 3/8-24 HELICAL INSERT
 $\varnothing 0.391 \times 1.25$ DP
 INSTALL HELICOIL MS124818
 FLUSH WITH SURFACE



D3957-2 HINGE, DOOR RH UPPER

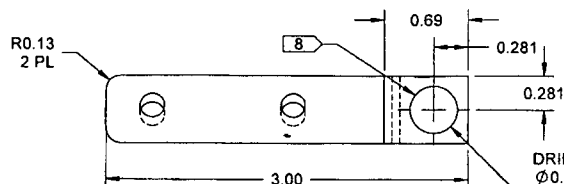
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- 1) MATERIAL: 6061-T6 (6061-T651/T6510/T6511/T62) ALUMINUM BAR
 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
 PER AMS-QQ-A-200/8 (OR AMS 4160)
 REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.10 lbs
- 8) MASK HOLE PRIOR TO POWDER COAT

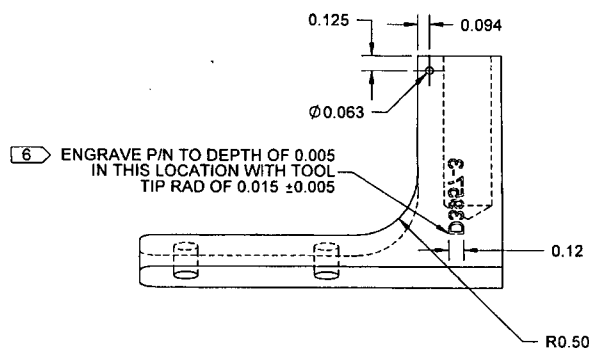
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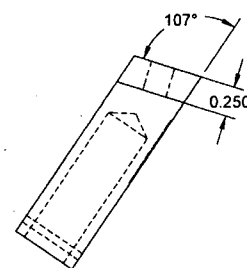
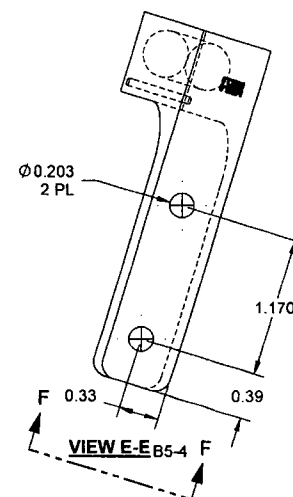
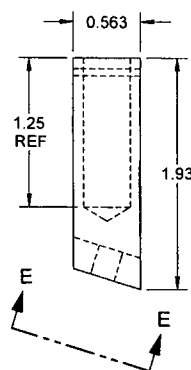
WLO 53439



DRILL AND TAP FOR 3/8-24 HELICAL INSERT
 $\varnothing 0.391$ X 1.25 DP
 INSTALL HELICOIL MS124818
 FLUSH WITH SURFACE



6 ENGRAVE P/N TO DEPTH OF 0.005
 IN THIS LOCATION WITH TOOL
 TIP RAD OF 0.015 ± 0.005



VIEW F-F C3-4

D3957-3 HINGE, DOOR LH LOWER

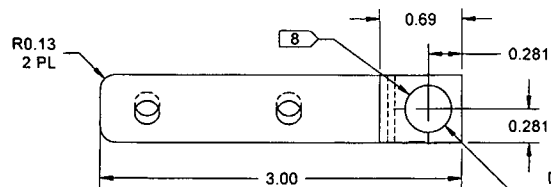
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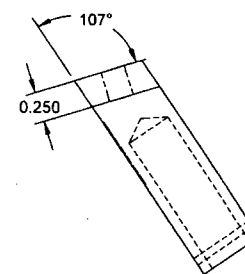
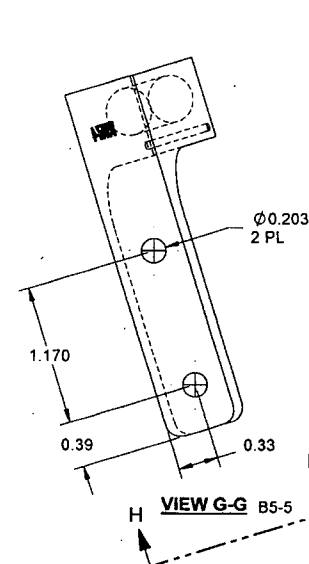
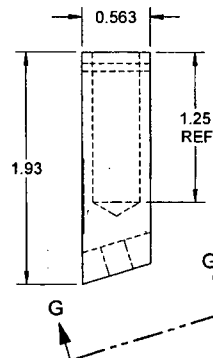
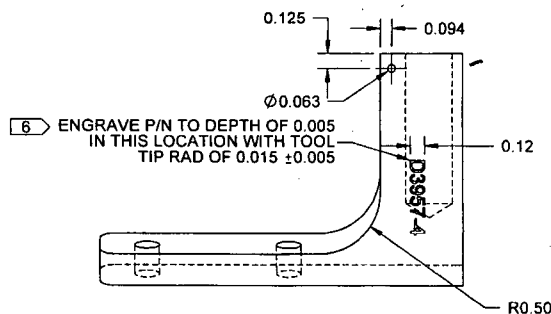
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 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
 PER AMS-QQ-A-200/8 (OR AMS 4160)
 REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.09 lbs
- 8) MASK HOLE PRIOR TO POWDER COAT

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3957	SHEET 4 OF 5
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WLO 53439



DRILL AND TAP FOR 3/8-24 HELICAL INSERT
 $\varnothing 0.391 \times 1.25$ DP
 INSTALL HELICOIL MS124818
 FLUSH WITH SURFACE



D3957-4 HINGE, DOOR RH LOWER

VIEW H-H C3-5

NOTES:

- 1) MATERIAL: 6061-T6 (6061-T651/T6510/T6511/T62) ALUMINUM BAR
 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
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- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.09 lbs
- 8) MASK HOLE PRIOR TO POWDER COAT

RELEASED
 2009-10-08

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D3957
MFG. APPR.		REV. A
APPROVED		SHEET 5 OF 5
DE APPR.		TITLE HINGE
DATE	09.09.03	SCALE NTS

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